

Work Order ID 60711

Tuesday, July 20, 2010 11:08:10 AM



SITIP TODAY Page 1

Item ID: D900-619-011

Revision ID:

Accept

Item Name: Bearpaw

Start Date: 7/20/2010 Start Qty: 2.00

Required Date: 7/20/2010 Req'd Qty: 2.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan: *MF*

Date: 10-7-20 Tooling:

QC:

Date: SPC (Y/N):

Date:

Run Start

Stop

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

IIN-D900-619

A

0.00

100



DC

Document Control

Memo

Photocopy bluefile & type labels per PPP D900-619-011
CHG003

0.00

S 10/12/20

110



Packaging

Pick Kit

0.00

Memo

0.00

Packaging

120



QC

Quality Control

QC4- 100% Inspect kits for completeness

Memo

0.00

0.00

S 10/12/20

10/20/20 (2)

(+2)

Work Order ID 60711

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Page 2

Item ID: D900-619-011

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Customer:

Setup Start

Stop

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Packaging

Packaging

Memo

Identify and pack for shipping as per PPP D900-619-011

Location:

PPP rev:

0.00

0.00

140



QC

Quality Control

QC21 - Final Inspection - Work Order Release

Memo

0.00

0.00

Handwritten signature and date: 10/7/20 @

Handwritten signature and date: MF 10-7-20

Picklist Print

Tuesday, July 20, 2010 11:08:10 AM

Page 1

Work Order ID: 60711

Parent Item: D900-619-011

Parent Item Name: Bearpaw

Start Date: 7/20/2010

Start Qty: 2.00

Required Date: 7/20/2010

Required Qty: 2.00

Comments:

IPP .C004.02.17 Blank size changed on Step 3 KJ/JLM
IPP Rev:D Was k10010 07-01-03 JLM
IPP Rev:E New Manufacturing Method 08-11-04 Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN4-15A



Bolt

Purchased

No

110

Each

399.0000

8

16

Location

ST358

Loc Qty

399

Loc Code

114615

12

114784

87

115108

300

110

Each

0.0000

8

16

AN960JD416



Washer

D2182B



Rubber Cushion

NAS1149D0463J

Purchased

No

Manufactured

No

110

f

252.5452

2

4

Location

ST402A

Loc Qty

9.67

Loc Code

30872

9.67

ST410

242.8752

52649

242.8752

110

Each

351.0000

8

16

(D2182B060) cut 4 at 6.00" as per dwg per kit

D2274



Radius Block

Manufactured

No

Location

ST010

Loc Qty

351

Loc Code

57912

131

59108

220

11/4/08

113706

52649

53602

11/11/2002

Picklist Print

Tuesday, July 20, 2010 11:08:10 AM

Page 2

Work Order ID: 60711

Parent Item: D900-619-011

Parent Item Name: Bearpaw

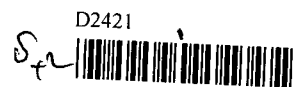


Start Date: 7/20/2010

Required Date: 7/20/2010

Start Qty: 2.00

Required Qty: 2.00



D2421

Manufactured No

110 Each

0.0000

2 4

Bearpaw, 900

D2519

Manufactured No

110 Each

36.0000

4 8



Clamp

Location

Loc Qty

Loc Code

ST456

56763

36

36

110 Each

334.0000

8 16

D2529

Washer

Location

Loc Qty

Loc Code

ST017

58568

334

334

110 Each

3,978.000

8 16

MS21042L4

Nut

Purchased No

Location

Loc Qty

Loc Code

ST300

113422

114523

114718

114784

115108

3978

68

28

23

1859

2000



Tuesday, July 20, 2010 11:08:10 AM

Shop Packet Print

Page 2

Picklist Print

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Parent Item: D900-619-011

Parent Item Name: Bearpaw

Page 3

13

QS100-M24S



S
X Clamp

Purchased

No

110

Each

36.0000

Start Date: 7/20/2010

Start Qty: 2.00

Required Date: 7/20/2010

Required Qty: 2.00

4 8



Location

ST449

114619

114885

Loc Qty

36

26

10

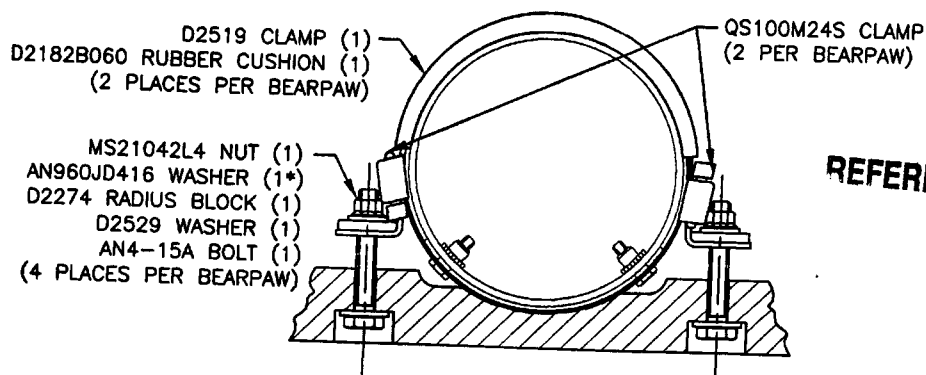
Loc Code

7/11/6/19

Tuesday, July 20, 2010 11:08:10 AM

Shop Packet Print

Page 3



* See note 6

Figure 32-2: Bearpaw Installation (section view)

6. Additional AN960JD416 washers may be installed under the nuts to ensure 1.5-4 threads in safety on the bolts. Although not generally necessary, it is also acceptable to replace the AN4-15A bolts with longer or shorter AN4 bolts, if required.
7. Lower the aircraft

32.2 BEARPAW REMOVAL

1. Jack up the aircraft.
2. Loosen the clamp bolts and remove the bearpaws and clamps. Ensure the skidtubes are serviceable.
3. Lower the aircraft.

32.3 WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D900-619-011 Bearpaw Installation	13.8 lb 6.3 kg	0.0 in 0.0 m	0.0 lb-kG 0.0 m-kG	233.3 in 5.93 m	3220 in-lb 37.4 m-kG

32.4 PARTS LIST

Qty	Part Number	Description
X	D900-619-011	BEARPAW INSTALLATION
4	D2182B060	RUBBER CUSHION
8	D2274	RADIUS BLOCK
2	D2421	BEARPAW
4	D2519	CLAMP
8	D2529	WASHER
8	AN4-15A	BOLT
8	AN960JD416	WASHER
8	MS21042L4	NUT (OR MS21042-4)
4	QS100M24S	CLAMP

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Revision: 0

32-00-00
Page 3 (4 blank) of 4

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Start



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QC

Memo

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Quality Control

REFERENCE ONLY

10-7-20
(2)